

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017162**Date Inspected:** 30-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Lv Li Qing/Li yun hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Nagalingam Pandaram Pillai was present during the times noted above for observations relative to the work being performed.

Magnetic Particle Testing:-

Bay #14

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control Personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Segment 13AE Bottom Plate. The weld designation reviewed is as follows:

SEG3007AC-001,003A/B

SEG3007AC-002A

In process Inspection

Bay #16

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 13BW, weld No: LD3032-001-057. The welder is identified as #045143. ABF QA is identified as Mr.Li Zhi You. The welding variables recorded by QC appear to comply with

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WPS-B-T-2233-TC-U5-F.

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 13 AW, weld No: LD3034-001-186. The welder is identified as #206358. ABF QA is identified as Mr. Li Zhi You. The welding variables recorded by QC appear to comply with WPS-B-T-2232-B-U5-F.

OUTSIDE YARD

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: DP3029-001-023 located on OBG Segment 12CE. Welder is identified as #054013. ZPMC CWI is identified as Mr. Li ping. Welding was performed according to the weld repair report B-WR13271 and UT report number: B787-UT-13191. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-3G(3F)-Repair. Please see the attached picture.

This QA inspector observed the following work in progress:

SMAW welding of weld joint no: SEG3002E-018 located on OBG Segment 12BE. Welder is identified as #043661. ZPMC CWI is identified as Mr. Li yun hua. Welding was performed according to the Critical weld repair report B-CWR1983 and UT report number: B787-UT-15325. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G(1F)-FCM-Repair. Please see the attached picture.

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12CE, weld No: SEG3003M-021. The welder is identified as #043661. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM.

Visual Inspection after Blast

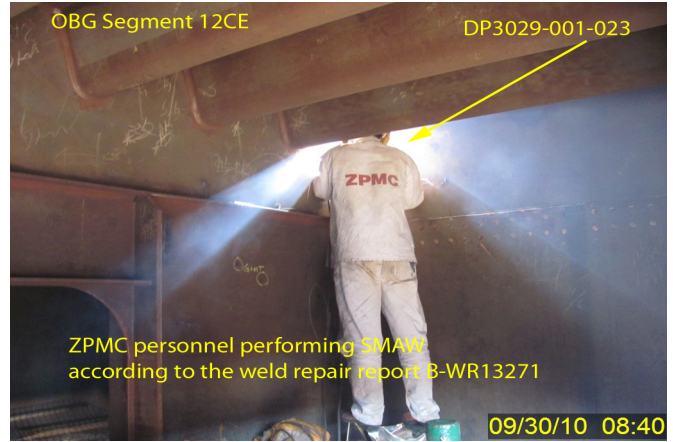
Segment 11EW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the Interior components of the Side panels and Bottom panel of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Pillai,Pandaram | Quality Assurance Inspector |
| Reviewed By: | McClendon,Timothy | QA Reviewer |
